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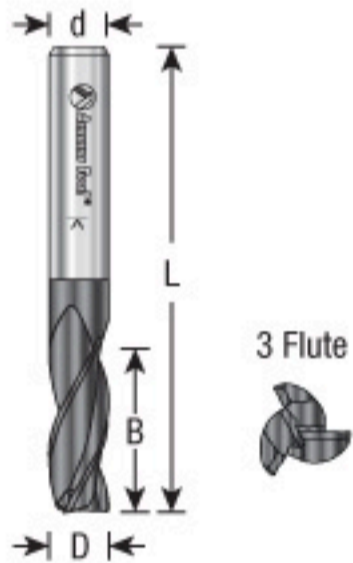
3 Flute
 Center Cut Helical
 Up-Cut

Specially designed for working in Metal working Steel Cold roll, soft steels, gummy stainless 303, Tool steels, exotics like titanium, inconel, 17-4PH stainless etc. Entire gambit of "steel"

! To achieve the best results and maximum tool life use of lubricant / coolant is strongly recommended.

TiAIN coating benefits:

1. High resistance to wear
2. Allows for faster feed and speed rates.
3. Cutting edge protected from wear
4. Better chip evacuation
5. Less heat build up
6. Superior cutting quality and extended tool life



D	B	d	L	Tool No.
1/8	1/2	1/4	1-1/2	51460
3/16	7/16	1/4	1-7/8	51462
1/4	5/8	1/4	2-3/8	51464

MAX RPM: 28,000

Working Speed and Feeds

Material Group	Speed SFM*	Feed Per Tooth (Inch Per Tooth) Diameter equals			
		up to 1/4"	1/4" to 1/2"	1/2" to 3/4"	3/4" to 1"
Aluminum/Related Alloys	600-1200	.001-.002	.002-.004	.004-.006	.006-.008
Brass/Bronze	300-550	.001-.002	.002-.003	.003-.004	.004-.005
Copper/Related Alloys	500-900	.001-.002	.002-.003	.003-.005	.005-.008
Cast Iron (soft 195bhn)	200-500	.001-.002	.002-.003	.003-.005	.005-.008
Cast Iron (medium 225bhn)	125-350	.001-.002	.002-.003	.003-.004	.004-.007
Cast Iron (hard 275bhn)	80-300	.0005-.001	.001-.002	.002-.003	.003-.005
Magnesium	800-1400	.001-.003	.003-.005	.005-.007	.007-.009
Monel/Nickel Alloys	65-175	.0005-.001	.001-.002	.002-.003	.003-.004
Plastics	600-1200	.001-.003	.003-.006	.006-.010	.010-.015
Steel-Heat Treated (35-40Rc)	150-350	.0003-.0005	.0005-.001	.001-.003	.003-.005
Steel-Heat Treated (40-45Rc)	125-275	.0002-.0005	.0005-.001	.001-.002	.002-.004
Steel-Heat Treated (45Rc)	50-200	.0002-.0005	.0005-.001	.001-.002	.002-.003
Steel-Medium Carbon	175-350	.0005-.001	.001-.002	.002-.004	.004-.006
Steel, Mold & Die	50-250	.0005-.001	.001-.002	.002-.004	.004-.007
Steel, Tool	150-250	.0005-.001	.001-.002	.002-.004	.004-.006
Stainless-Soft	250-400	.0005-.001	.001-.002	.002-.004	.004-.006
Stainless-Hard	75-250	.0005-.001	.001-.002	.002-.003	.003-.005
Titanium Alloys	90-225	.0003-.0009	.0009-.002	.002-.003	.003-.005

* Surface Feet/Minute
 SFM = 0.262 x Dia. x RPM

